

# ZINCANODE<sup>®</sup> 402

Two Pack Zinc Rich Epoxy Primer

PC 122

- FEATURES**
- OVERCOAT WITH EPOXIES, POLYURETHANE, CHLOR RUBBERS WITHOUT SPECIAL TECHNIQUES
  - ECONOMICAL AND USER FRIENDLY EPOXY ZINC COATING
  - PROVIDES EXCELLENT CORROSION PROTECTION
  - RAPID DRY AND OVERCOAT TIMES
  - SUITABLE FOR USE IN ENVIRONMENTS UP TO 200°C

**USES** ZINCANODE<sup>®</sup> 402 is a two-pack epoxy zinc rich primer designed to provide exceptional corrosion resistance in harsh exposures by sacrificial methods.  
ZINCANODE<sup>®</sup> 402 is recommended for use over abrasive blast cleaned steel surfaces in most harsh environments, especially where overcoating is required without special mist or seal coat techniques.  
ZINCANODE<sup>®</sup> 402 offers ease of application, high film builds without mud-cracking and exceptional adhesion to field weld areas cleaned by power sanding or power wire brushing. It is specified for use in power generation plants, bulk handling equipment and oil refineries. Also in mining and chemical processes, offshore structures and exposed pipelines.

**SPECIFICATIONS** Approved to APAS 2916  
AS/NZS 3750-9 Type 2

## RESISTANCE GUIDE

<b>HEAT RESISTANCE</b>	Up to 200°C dry heat.	<b>ALKALIS</b>	Do not use in strongly alkaline conditions unless suitably topcoated.
<b>WEATHERABILITY</b>	Epoxy coatings may yellow with time. On exterior exposure some chalking may also occur. This will not detract from the protective properties of the coating. Use a weatherable topcoat if required for appearance.	<b>SALTS</b>	Excellent resistance to neutral and alkali salts when suitably topcoated.
<b>SOLVENTS</b>	Resists splash and spillage of aromatic hydrocarbon solvents and most common alcohols.	<b>WATER</b>	Suitable for immersion in fresh and salt water when suitably topcoated.
<b>ACIDS</b>	Not recommended for acid conditions.	<b>ABRASION</b>	Very good when fully cured.

## TYPICAL PROPERTIES AND APPLICATION DATA

<b>CLASSIFICATION</b>	Zinc Rich Epoxy Primer	<b>APPLICATION CONDITIONS</b>	Min	Max	
<b>FINISH</b>	Matt	Air Temperature	10°C	45°C	
<b>COLOUR</b>	Grey-Green	Substrate Surface Temperature	10°C	45°C	
<b>COMPONENTS</b>	Two	Relative Humidity		85%	
<b>SOLIDS BY VOLUME</b>	48%		Min	Max	Recom.
<b>VOC LEVEL</b>	<460 g/L	Wet film per coat (microns)	125	165	155
<b>FLASH POINT</b>	Base 32°C, Hardener 25°C	Dry film per coat (microns)	60	80	75
<b>POT LIFE</b>	8 Hours (25°C)	<b>SUITABLE SUBSTRATES</b>	Abrasive blast cleaned steel.		
<b>MIXING RATIO (V/V)</b>	Part A : 4      Part B : 1	<b>TOPCOATS</b>	Single and two pack products.		
<b>THINNER</b>	920-08925      Dulux <sup>®</sup> Epoxy Thinner	<b>APPLICATION METHODS</b>	Conventional, airless spray or air assisted spray. Brush and roller for small areas.		
<b>PRODUCT CODE</b>	730-81386      Part A 976-63033      Hardener				

Drying characteristics at 75 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure	Overcoat	
					Min	Max*
10° C	50%	2 Hours	17 Hours	7 Days	17 Hours	Indefinite
15° C	50%	2 Hours	10 Hours	7 Days	10 Hours	Indefinite
25° C	50%	1 Hour	5 Hours	7 Days	5 Hours	Indefinite

These figures are given as a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

\* When used for non-immersion conditions. Refer to PRECAUTIONS section for overcoating intervals and requirements for immersion service.

## TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 6.4 sq. metres per litre corresponds to 75 microns dry film thickness assuming no losses. Practical spreading rates will vary depending on such factors as method and conditions of application and surface roughness.

# ZINCANODE® 402

## TYPICAL SYSTEMS

(The typical systems are offered as a guide only and are not to be used as a specification. It is recommended that the specific needs of a project be discussed with a Dulux Protective Coatings Consultant.)

SURFACE	PREPARATION GUIDE	SYSTEM		DRY FILM THICKNESS
STEEL	Abrasive blast AS1627.4 Class 2.5 Abrasive blast to AS1627.4 Class 3.0 for immersion service	1st Coat	ZINCANODE® 402	75 Microns
		2nd Coat	FERREKO® No 3	100 Microns
		3rd Coat	FERREKO® No 3	100 Microns
		1st Coat	ZINCANODE® 402	75 Microns
		2nd Coat	DUREMAX® GPE	125 Microns
		3rd Coat	WEATHERMAX™ HBR	100 Microns
		1st Coat	ZINCANODE® 402	75 Microns
		2nd Coat	LUXATHANE® R	50 Microns

### SURFACE PREPARATION

#### Steel:

Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Rust, millscale, oxide deposits and old paint films on metal surfaces must be removed by abrasive blast cleaning to a minimum of AS1627.4 Class 2.5. Immersed steel must be prepared to AS1627.4 Class 3.

### APPLICATION

Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 10 minutes. Ensure the clean-up solvent is available before commencing application. Remix thoroughly before using and continue mixing during application.

### BRUSH/ROLLER

For small areas only. Apply even coats of the mixed material to the prepared surface. Thinning is not normally required, however, up to 50ml/litre of Dulux® Epoxy Thinner (920-08925) can be added to ease application. When brushing and rolling additional coats may be required to attain the specified thickness.

### CONVENTIONAL SPRAY

Thinning is not normally required, however, up to 50ml/litre of Dulux® Epoxy Thinner (920-08925) can be added to ease application. Ensure paint is regularly agitated during application to prevent separation.

#### Typical Set-up

Graco Delta Gun: 1.8mm (239543)  
Pressure at Pot: 70-105 kPa (10-15 p.s.i.)  
Pressure at Gun: 380-415 kPa (55-60 p.s.i.)

### AIRLESS SPRAY

Standard airless spray equipment such as a Graco 33:1 Bulldog or 45:1 Xtreme with a fluid tip of 15-17 thou (0.38-0.43mm) and an air supply capable of delivering 550-690 kPa (80-100 p.s.i.) at the pump. Ensure paint is regularly agitated during application to prevent separation. Thinning is not normally required but up to 50 ml/litre of Dulux® Epoxy Thinner (920-08925) may be added to ease application.

### PRECAUTIONS

This is an industrial product designed for use by experienced Protective Coating applicators. Where conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux® representative for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express written consent of Dulux® Australia. Freshly mixed material must not be added to material that has been mixed for some time. The rate of cure is dependent upon temperature. Do not apply at temperatures below 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. When used for immersion conditions the maximum overcoat interval is 3 days at 25°C. The coating MUST be fully cured and solvent free prior to being placed under immersion conditions. For best results in water immersion conditions replace Dulux® Epoxy Thinner (920-08925) with CR Reducer (965-63020). Topcoats of a saponifiable nature such as alkyls must never be applied directly to ZINCANODE® 402.

### CLEAN UP

Clean all equipment with Dulux® Epoxy Thinner (920-08925) immediately after use.

### OVERCOATING

Aged coating should be tested for lifting by a method appropriate for the coating thickness, for example 'X' cut or cross-hatch methods. If it lifts, remove it. The surface must be free of oil, grease and other contaminants. High pressure water wash at 8.3 to 10.3 MPa (1,200- 1,500 p.s.i.) to remove loosely adhering chalk and dust.

### SAFETY PRECAUTIONS

#### Read Data Sheet, Material Safety Data Sheet and any precautionary labels on containers.

Contents of container may be under pressure. Containers should be carefully opened by first placing a rag, then a hand, over the lid then gently easing the lid off.

### STORAGE

Store as required for a flammable liquid Class 3 in a bunded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.

### HANDLING

As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS1337 should be worn where there is a risk of splashes entering the eyes. Always wash hands before smoking, eating, drinking or using the toilet.

### USING

Use with good ventilation and avoid inhalation of spray mists and fumes. If risk of inhalation of spray mists exists, wear combined organic vapour/particulate respirator. When spray painting, users should comply with the provisions of the respective State Spray Painting Regulations.

### FLAMMABILITY

This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO<sub>2</sub> or dry chemical powder. On burning will emit toxic fumes.

### WELDING

Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.

**MATERIAL SAFETY DATA SHEET is available from Customer Service (132377) or [www.duluxprotectivecoatings.com.au](http://www.duluxprotectivecoatings.com.au)**

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A.B.N. 67 000 049 427  
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PACKAGING	Available in 4 litre and 10 litre packs
TRANSPORTATION WEIGHT	2.12 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263
	Part B: Class 3 UN 1263

Any advice, recommendation, information, assistance or service provided by DULUX Australia in relation to goods manufactured by it or their use and application is given in good faith and is believed by Dulux to be appropriate and reliable. However, any advice, recommendation, information, assistance or service provided by Dulux is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the right entitlements and remedies conferred upon any person or the liabilities imposed upon Dulux by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance void or prohibiting such exclusion limitation or modification. Products can be expected to perform as indicated in this sheet so long as applications and application procedures are as recommended. Specific advice should be sought from Dulux for application in coastal areas and for large projects to ensure proper performance.